

Work Order ID 81602***81602***

Page 1

Item ID: D3315-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate

Start Date: 15/03/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/03/16

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3315

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3315

Dwg Rev: BProg Rev: B

2-Deburr if necessary

1010 063

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8 0 Jm 12-6-25

8 0 Jm 12-6-25

8 12-6-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81602

March-16-12 8:36:05 AM

81602

Page 2

Item ID: D3315-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate
 Start Date: 15/03/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 29/03/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo 1- Form using DT8751 Die as per Dwg D3315Rev: <u>B</u> 2- Form using DT8179 Die as per Dwg D3315Rev: <u>B</u>	0.00 0.00				8			SB 12/06/12
140 *140* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00				(X8)			5
150 *150* Large Fab Large Fab	Large Fab Memo Weld hard surface using D3315-ST3 as per QSI 004 and Dwg D3315 Rev: <u>B</u> Qty Part Number Description Batch A/R N/A 7560 Hardcoat Rod <u>m 122359</u>	0.00 0.00				(X8)			ml 12-08-16

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March-16-12 8:36:05 AM

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Start Date: 15/03/2012 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 29/03/2012 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							
			(DAS 16 8-83)	12/08/16					
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
			SMB 12-8-16						
			(DAS 15 8-83)	12/08/16					
						8			
						-5			
180 *180* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: OVEN TEMPERATURE: FINISH TIME:	0.00 0.00							
			9:15						
			3200F						
			9:45						

m121279

8X ✓ 12/08/20

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Page 4

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 Required Date: 29/03/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00				8	0	12-8-20	
190									
QC	Memo	0.00							
Quality Control									
200	Packaging	0.00				8		12/8/23	
200									
Packaging	Memo	0.00							
Packaging	Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3315-5, B/N: BXXXXX For Product Eligibility see PDA04-17 and Stock Location: <u>500</u>								
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

MLJ 12/08/23

MF 12-08-23

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

March-16-12 8:36:08 AM

Page 1

Work Order ID: 81602

81602

Parent Item: D3315-5

D3315-5

Parent Item Name: Wearplate

Start Date: 15/03/2012

Required Date: 29/03/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: A05.05.12New issue KJ/JLM
IPP Rev:B As per Rev B 06-03-24 JLM
IPP Rev:C Now on Waterjet 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M1010S16GA

Purchased

No

100

sf

69.0000

1.8345

15.44842

M1010S16GA

1010/1025 sheet 16GA

**

JM 12-6-25

Location

Loc Qty

Loc Code

MAT019

69

116791

21.4

117500

17.6

118965

30

118965 1055F.

121195

121195 555F.

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	81602
Description: Wearplate		Part Number:	D3315-5
Inspection Dwg: D3315 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.31	+/-0.030	34.31"	✓		MT	MBOI
30.215	+/-0.010	30.215"	✓		MT	"
24.215	+/-0.010	24.215"	✓		MT	"
21.611	+/-0.010	21.611"	✓		MT	"
17.965	+/-0.010	17.965"	✓		MT	"
16.026	+/-0.010	16.026"	✓		MT	"
14.735	+/-0.010	14.735"	✓		MT	"
12.815	+/-0.010	12.815"	✓		MT	"
6.465	+/-0.010	6.467"	✓		V	mmoi
5.464	+/-0.010	5.454"	✓		✓	"
4.527	+/-0.010	4.531"	✓		✓	"
3.550	+/-0.010	3.559"	✓		✓	"
5.214	+/-0.010	5.204"	✓		✓	"
Ø0.300	+0.006/-0.001	0.303"	✓		✓	"
Ø0.266 x 0.575	+/-0.010	0.273" x 0.579"	✓		✓	"
Ø0.266 x 0.450	+/-0.010	0.271" x 0.454"			✓	"

Measured by:	Jm	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	12-6-25	Date:	12/06/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.22	New Issue	KJ/EC/DD	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

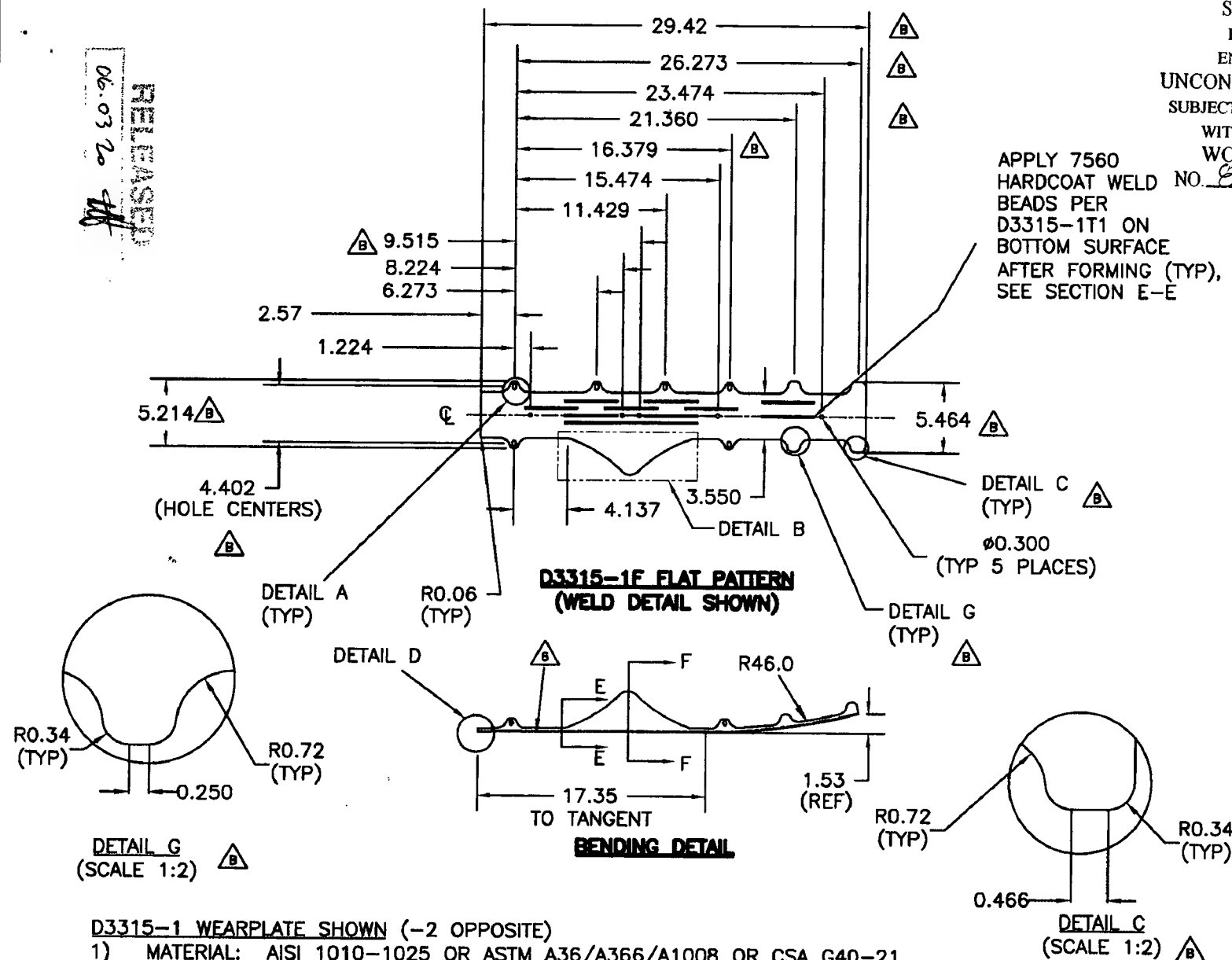
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
06.03.20



D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
 - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
 - 3) WELD PER DART QSI 004
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- "TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

APPLY 7560
HARDCOAT WELD
BEADS PER
D3315-1T1 ON
BOTTOM SURFACE
AFTER FORMING (TYP),
SEE SECTION E-E

NO. 81602 MLCJ
12/03/16

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
PH	PH	HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3315
DATE	TITLE	SHEET 1 OF 4
06.01.31	WEARPLATE	SCALE
A	04.09.10	1:12
B	06.01.31	
	UPDATE DIMENSIONS	
	NEW ISSUE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

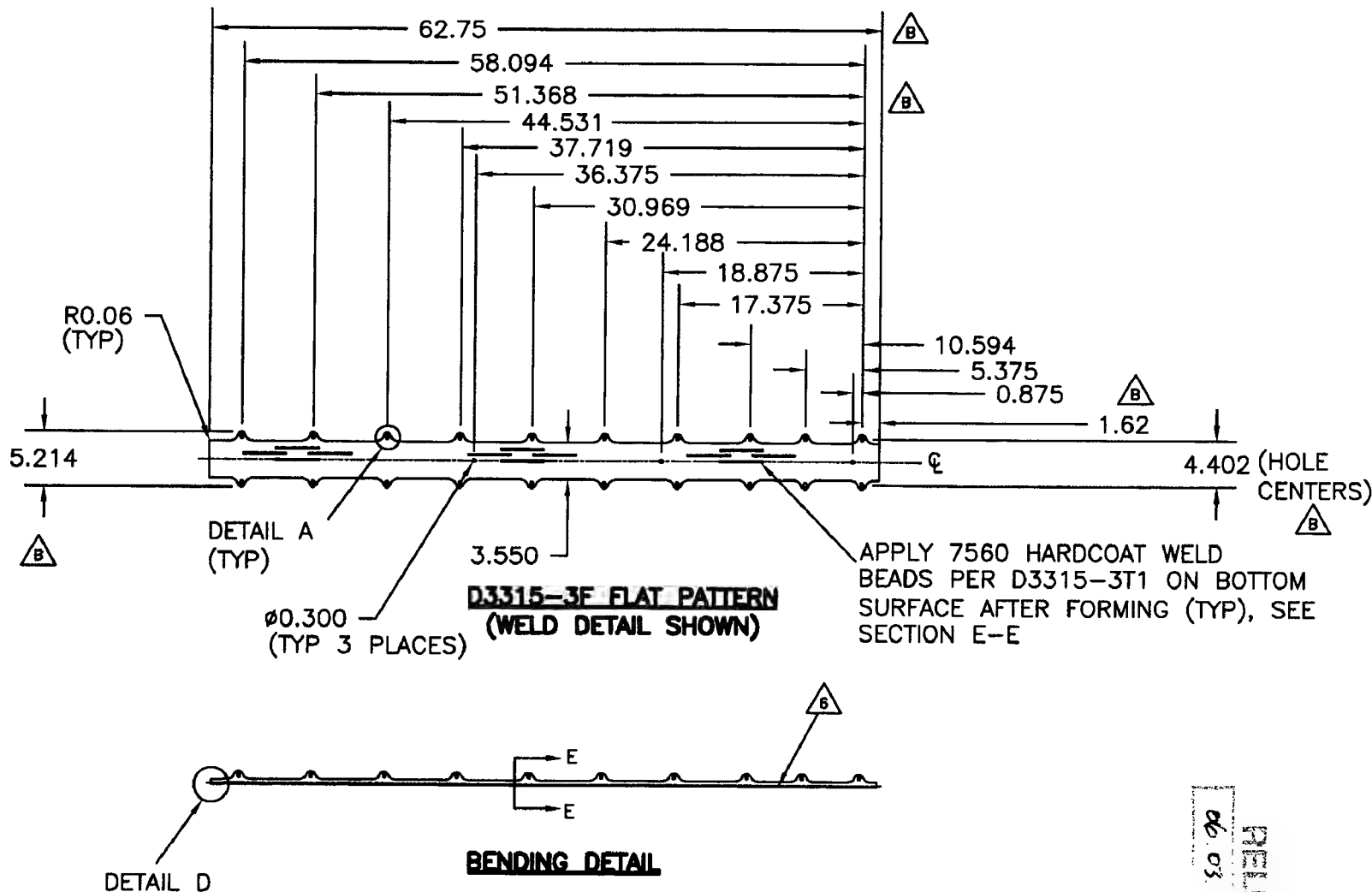
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81602

DART**D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
 - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
 - 3) WELD PER DART QSI 004
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- *TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

RELEASED
06 03 20

DESIGN	04	DRAWN BY	04	DART AEROSPACE LTD
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	06.01.31	DRAWING NO.	D3315	REV. B
		TITLE	WEARPLATE	SHEET 2 OF 4
		SCALE	1:16	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

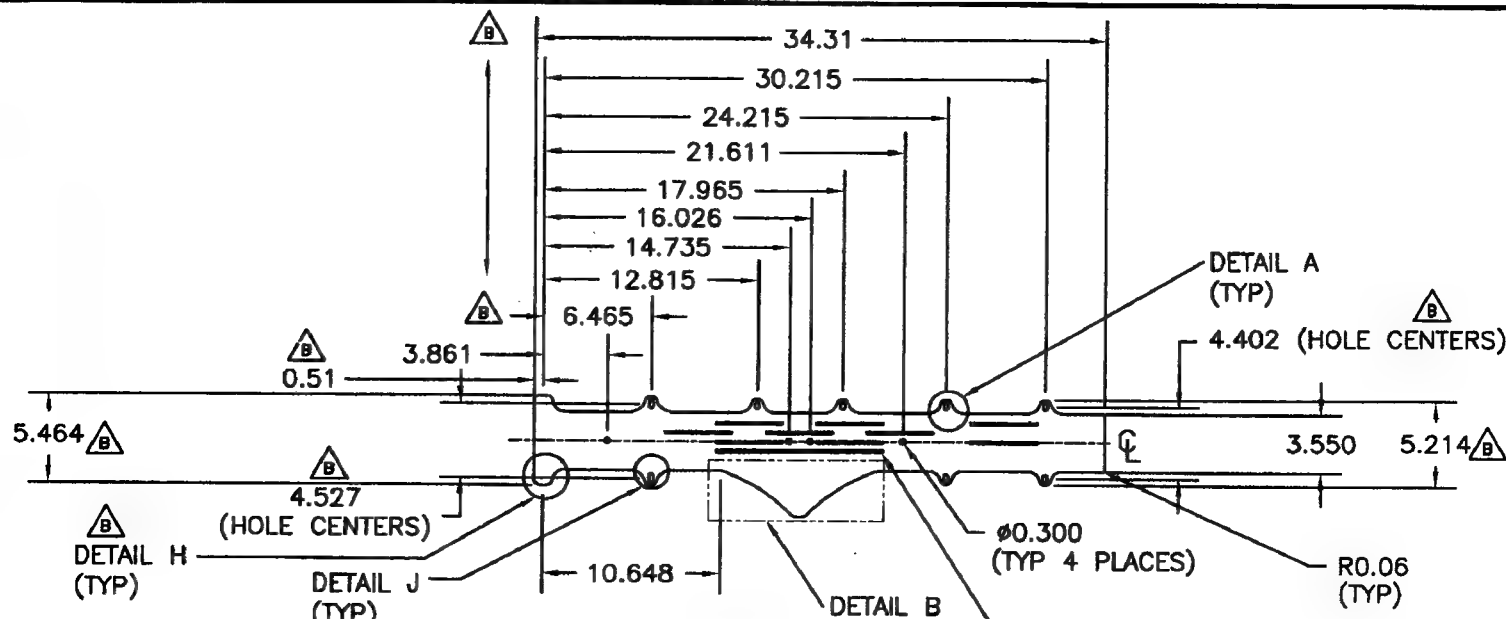
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

21602

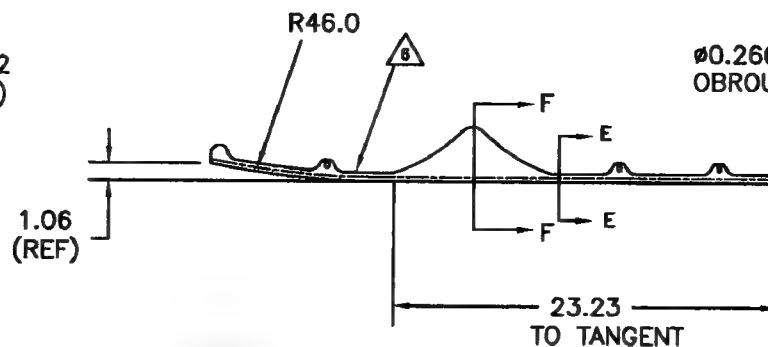
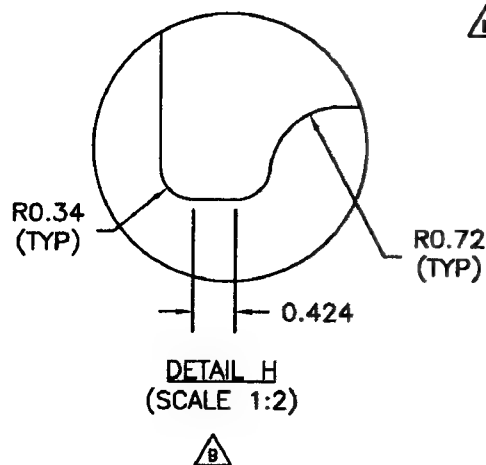
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
014	014	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3315
DATE	TITLE	REV. B
06.01.31	WEARPLATE	SHEET 3 OF 4
		SCALE 1:12

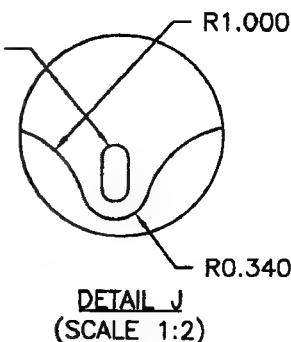


**D3315-5F FLAT PATTERN
(WELD DETAIL SHOWN)**

APPLY 7560 HARDCOAT WELD
BEADS PER D3315-5T1 ON BOTTOM SURFACE
AFTER FORMING (TYP), SEE SECTION E-E



BENDING DETAIL



D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

06 03 20

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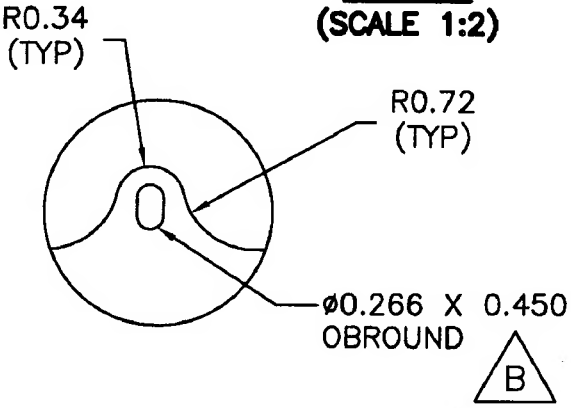
NOTE: Date & initial all entries

21602

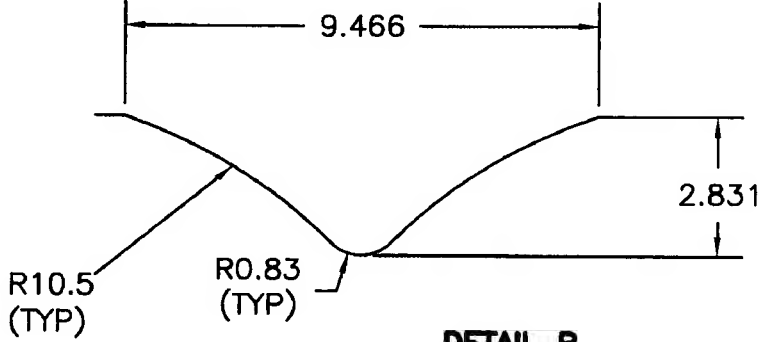
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
PH	PH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3315
DATE	TITLE	REV. B
06.01.31	WEARPLATE	SHEET 4 OF 4
		SCALE
		NTS

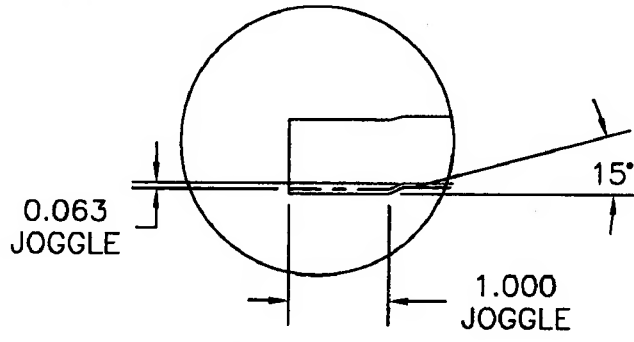
DETAIL A
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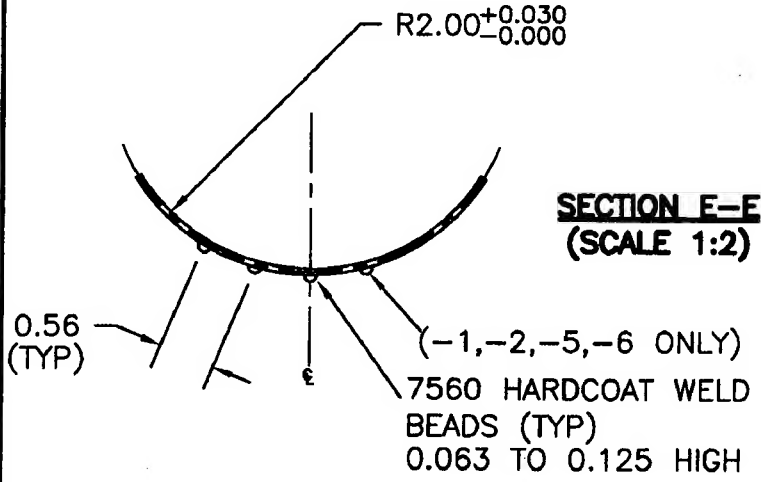
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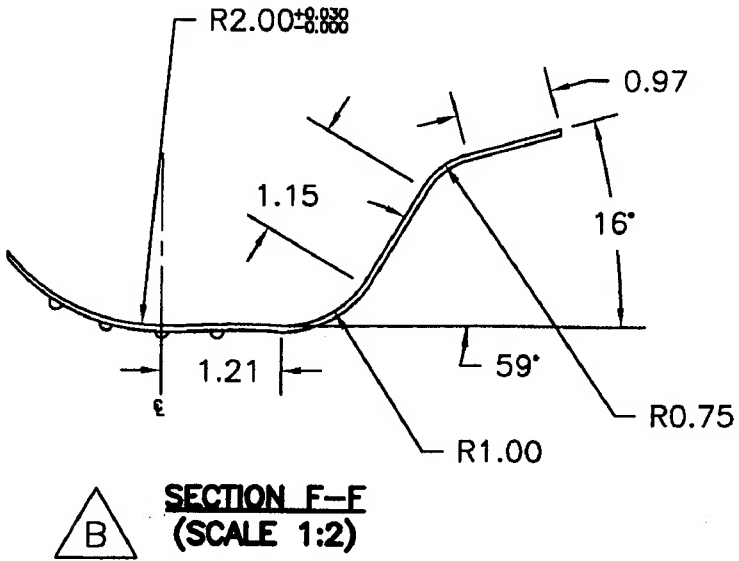
DETAIL D
(SCALE 1:2)



SECTION E-E
(SCALE 1:2)



SECTION F-F
(SCALE 1:2)



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06.03.20

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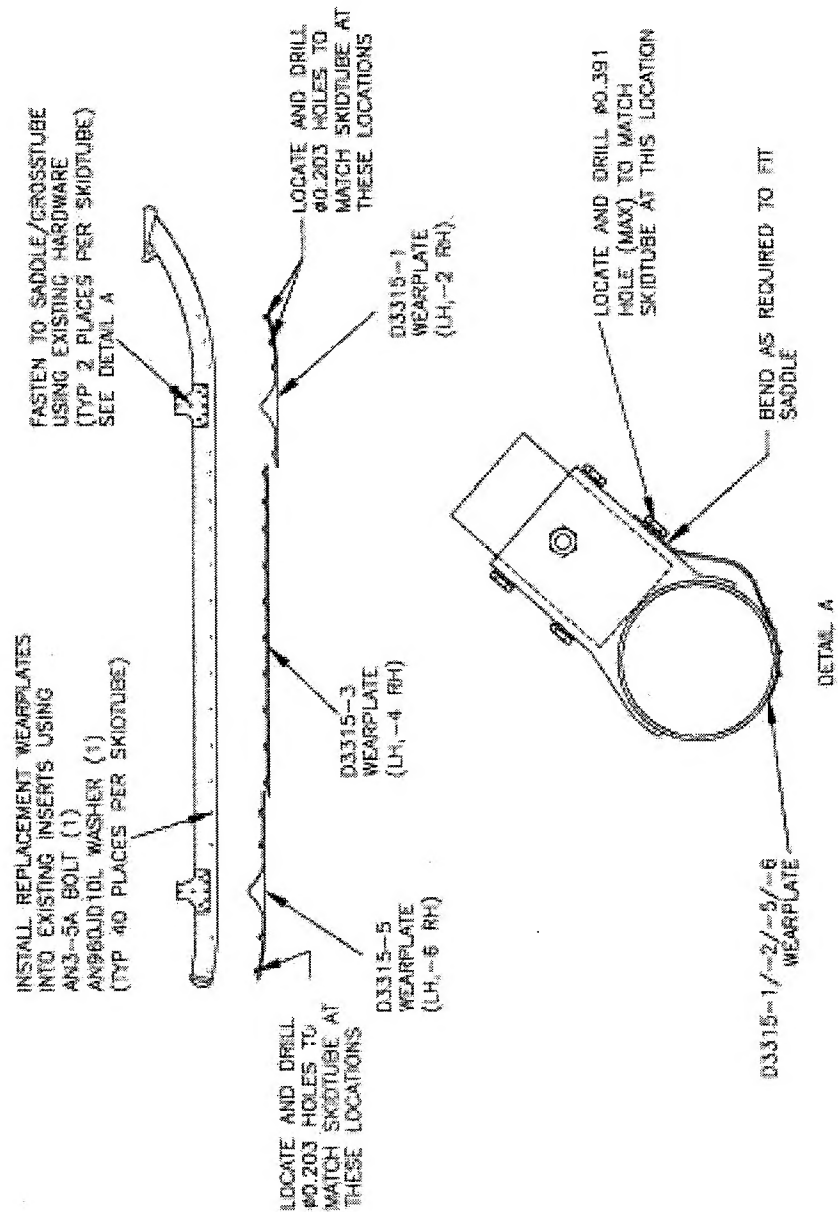
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FIGURE 1: D412-726-111 WEARPLATE KIT
(205/212/412 STANDARD SKIDTUBE)
(LH SKIDTUBE SHOWN, VIEW LOOKING OUTBOARD)
(RH OPPOSITE)



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Revision: **B**
 Date: 06.03.08